

Work Order ID 75153

75153

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October-18-11 2:44:46 PM

Item ID: D3065-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Leg
 Start Date: 18/10/2011 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D Dwg Rev: B Prog Rev: B 2-Deburr
6061 . 080 if necessary
B11-3
80

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control
B11-3

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control
11 . 11 - 04 (80)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00				80	BR	11-11-8.	
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location <i>GA</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

80X Ø M / 11/11/08

ES 11/11/10 (80)

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 18/10/2011 **Start Qty:** 80.00

80

Cust Item ID:

Required Date: 04/11/2011 **Req'd Qty:** 80.00

80

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

11/11/14 

11-11-11
(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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75153

Parent Item: D3065-5

D3065-5

Parent Item Name: Step Leg

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP: C02.11.01 Incorporated D3066-1 IPPKJ/RF

IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	270.8000	0.825	69.47368			

M6061T6S 080

6061-T6 .080 Sheet

**

B11-11-3

Location

Loc Qty

Loc Code

MAT021

270.8

117285

18.8

119009

171

119028

81

119028

80

W/O:		WORK ORDER CHANGES					
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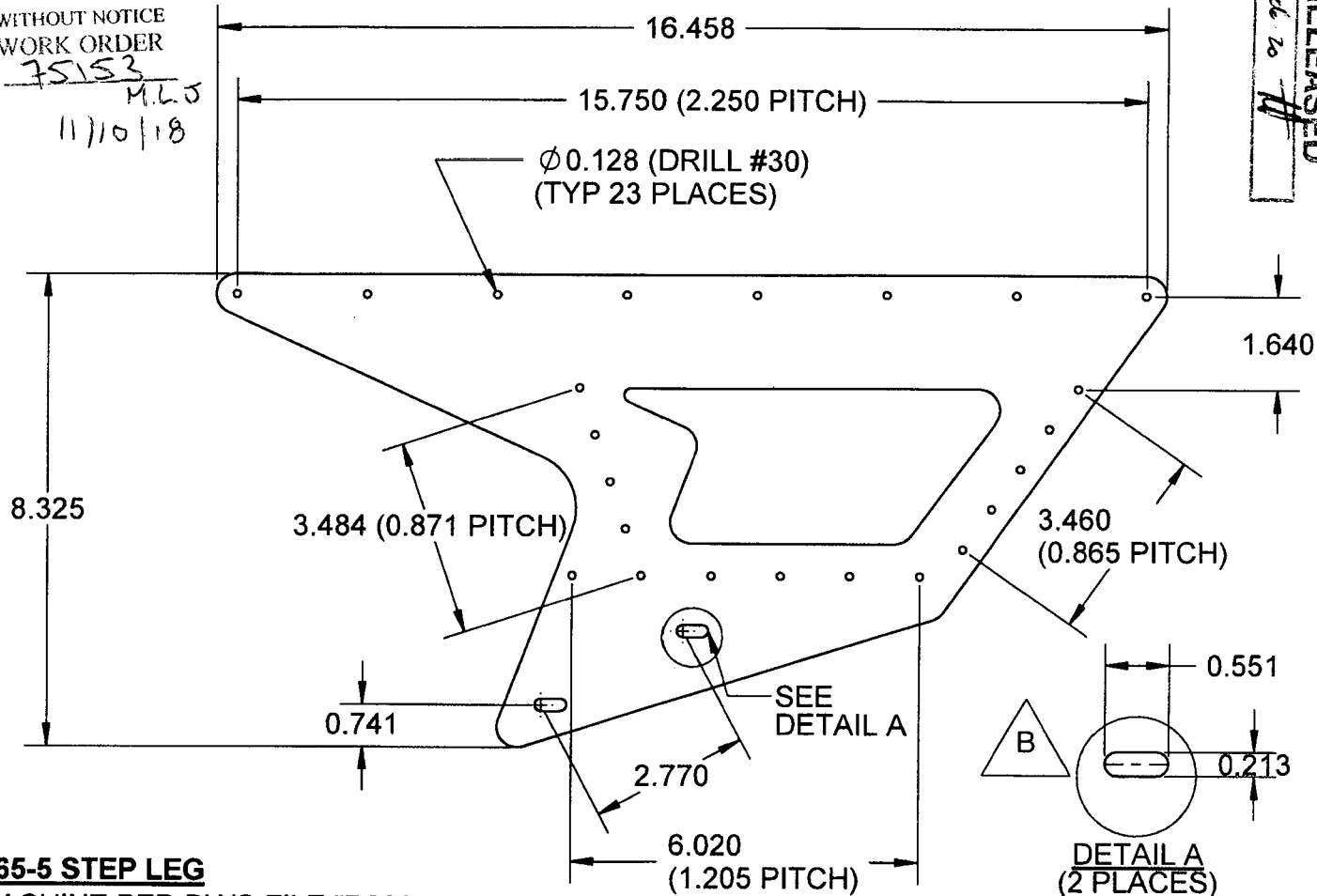
NOTE: Date & initial all entries

DART

DESIGN	<i>CP</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>SH</i>	APPROVED	<i>SH</i>	DRAWING NO. D3065
DATE	06.05.23			REV. B
				SHEET 4 OF 5
				SCALE 1:3
				TITLE STEP LEG ASSEMBLY

RELEASED
06.06.20

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 75153
M.L.S
11/10/18



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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